

Ship W/O 18 Oct

Ezele
PRELIMINARY ISSUE

Work Order ID 62778

Friday, October 08, 2010 9:07:40 AM



Item ID:	D407-802-011	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Crew Door Opener Installation, LH					
Start Date:	10/8/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	10/15/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-10-08	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-1	PA1								
100		0.00							
	DOCUMENT CONTROL								<i>N/A</i>
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D407-802-011								
	CHG001								
105		0.00							
	Pick Kit								
Packaging	Memo	0.00							<i>10/14/18</i>
Packaging									
110		0.00							
	QC4- 100% Inspect kits for completeness								
QC	Memo	0.00							<i>1</i>
Quality Control	for test kitting								<i>10/10/18</i>
	2 Engbl.								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62778

Friday, October 08, 2010 9:07:40 AM

Page 2

Item ID: D407-802-011

Accept

Revision ID: PRELIM

Item Name: Crew Door Opener Installation, LH

Start Date: 10/8/2010 Start Qty: 1.00

Required Date: 10/15/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD407-802-011

Location: _____

PPP rev: _____

130

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

R1348 Oct

POSITIVE RECALL

EFFECTIVE 10-11-02 AUTH h

RELEASED _____ DATE _____

10-11-02 test only

10-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Friday, October 08, 2010 9:07:43 AM

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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62296

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 08, 2010 9:07:43 AM

Work Order ID: 62778

Parent Item: D407-802-011



Parent Item Name: Crew Door Opener Installation, LH

Start Date: 10/8/2010



Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00



 D4106-7

 Template

Manufactured No 105 Each 4.0000


1 1
 

Location Loc Qty Loc Code

ST124 4
 62295 4

 CR3523-4-02 13*13 ✓

 RIVET

Purchased No 105 Each 455.0000

26 26
 



Location Loc Qty Loc Code

ST312 300
 115768 300
 ST313 155
 113064 155

 CR3523-4-4

 Rivet

Purchased No 105 Each 100.0000

4 4
 



Location Loc Qty Loc Code

ST314 100
 115768 100

 CR3523-4-5

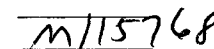
 Rivet

Purchased No 105 Each 100.0000

3 3
 

Location Loc Qty Loc Code

ST314 100
 115768 100



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, October 08, 2010 9:07:44 AM

Work Order ID: 62778

Parent Item: D407-802-011





Parent Item Name: Crew Door Opener Installation, LH

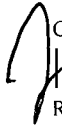



Start Date: 10/8/2010





Required Date: 10/15/2010

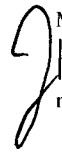



Start Qty: 1.00

Required Qty: 1.00

	CR3523-4-6  Rivet	Purchased	No	105	Each	100.0000	8	8	 
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
				ST314	100				
				115768	100				<u>M115768</u>

	CR3523-4-07  RIVET	Purchased	No	105	Each	82.0000	7	7	 
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
				ST313	82				
				17768	82				<u>17768</u>

	MS20426AD4-5  Rivet	Purchased	No	105	Each	5,866.000	4	4	 
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
				ST317	5866				
				6733	884				<u>6733</u>
				6874	4982				

	MS21073L5  nut plate	Purchased	No	105	Each	89.0000	2	2	 
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
				ST303	89				
				113660	89				<u>M113660</u>

M115768

17768

6733

M113660

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Friday, October 08, 2010 9:07:44 AM

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Work Order ID: 62778

Parent Item: D407-802-011

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0532R

Purchased

No

105

Each

144.0000

6

6



WASHER

Location

Loc Qty

Loc Code

ST297

144

114348

44

115531

100

m114348

NAS1149C0563R

Purchased

No

105

Each

200.0000

6

6



Washer

Location

Loc Qty

Loc Code

ST297

200

115768

200

m115768

2014/18 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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CHERRYMAX® RIVET SELECTION

INSTALLED WEIGHTS – Pounds per 1000 pieces (Ref.)

Rivet Diameter	Grip Length	Aluminum				Monel				INCO 600	
		Nominal		Oversize		Nominal		Oversize		Oversize	
		3212*	3213	3242	3243	3522*	3523	3552	3553	3852*	3853
		3214	3222*	3246*	3245	3524*		3556*	3555		
		3224*	3223	3252	3253						
		3224*			3255						
-4 (1/8")	-01*	.59	.69	.75	.88	—	1.28	1.10	1.32	—	1.35
	-02	.59	.79	.85	.99	1.05	1.52	1.14	1.58	1.16	1.61
	-03	.71	.93	.97	1.16	1.24	1.74	1.42	1.86	1.44	1.88
	-04	.86	1.07	1.14	1.33	1.44	1.90	1.70	2.14	1.72	2.17
	-05	1.00	1.21	1.31	1.50	1.66	2.16	1.98	2.42	2.01	2.44
	-06	1.14	1.36	1.47	1.66	1.88	2.38	2.26	2.70	2.28	2.73
	-07	1.28	1.50	1.64	1.83	2.00	2.61	2.54	2.98	2.56	3.02
	-08	1.42	1.64	1.81	2.00	2.22	2.83	2.82	3.26	2.89	3.29
	-09	1.56	1.78	1.98	2.17	2.44	3.05	3.10	3.54	3.22	3.66
-5 (5/32")	-01	—	1.26	—	1.55	—	2.41	—	2.46	—	2.53
	-02	1.02	1.41	1.34	1.71	1.84	2.81	1.87	2.90	1.99	2.98
	-03	1.22	1.63	1.56	1.98	2.15	3.14	2.26	3.34	2.37	3.44
	-04	1.45	1.86	1.82	2.24	2.50	3.46	2.87	3.78	2.90	3.91
	-05	1.67	2.08	2.09	2.51	2.86	3.81	3.30	4.22	3.33	4.26
	-06	1.90	2.31	2.36	2.78	3.22	4.17	3.74	4.66	3.85	4.77
	-07	2.12	2.53	2.63	3.05	3.58	4.53	4.18	5.10	4.31	5.21
	-08	2.35	2.75	2.90	3.32	3.94	4.92	4.62	5.54	4.75	5.67
	-09	2.57	2.98	3.16	3.58	4.29	5.24	5.06	5.98	5.19	6.13
	-10	2.79	3.20	3.43	3.85	4.64	5.56	5.50	6.42	5.63	6.55
	-11	3.01	3.42	3.70	4.12	4.99	5.87	5.94	6.86	6.07	6.97
-6 (3/16")	-01	—	2.01	—	2.39	—	3.84	—	3.99	—	4.13
	-02	1.75	2.20	2.00	2.58	3.04	4.38	3.12	4.51	3.24	4.65
	-03	2.00	2.52	2.28	2.93	3.54	4.87	3.69	5.08	3.82	5.22
	-04	2.33	2.85	2.62	3.27	4.04	5.38	4.27	5.66	4.33	5.80
	-05	2.64	3.16	2.97	3.62	4.54	5.86	4.85	6.24	4.97	6.37
	-06	2.97	3.49	3.32	3.97	5.04	6.36	5.43	6.82	5.55	6.95
	-07	3.28	3.80	3.67	4.32	5.54	6.86	6.01	7.40	6.13	7.53
	-08	3.61	4.13	4.02	4.67	6.04	7.36	6.59	7.98	6.72	8.11
	-09	3.93	4.45	4.36	5.01	6.54	7.86	7.17	8.56	7.30	8.69
	-10	4.25	4.77	4.71	5.36	7.04	8.35	7.75	9.14	7.88	9.27
	-11	4.57	5.09	5.06	5.71	7.54	8.85	8.33	9.72	8.47	9.85
	-12	4.90	5.42	5.41	6.06	8.04	9.34	8.91	10.30	9.05	10.44
-8 (1/4")	-02	—	4.79	—	—	—	9.17	—	9.92	—	10.28
	-03	4.08	5.35	4.50	5.74	6.98	10.01	7.45	10.95	7.73	11.37
	-04	4.61	5.92	5.32	6.57	7.63	10.80	8.58	11.98	8.90	12.42
	-05	5.14	6.49	5.71	7.14	8.98	12.29	9.71	13.01	10.07	13.41
	-06	5.67	7.06	6.28	7.81	10.04	13.28	10.84	14.04	11.24	14.54
	-07	6.20	7.63	6.91	8.48	11.05	14.20	11.97	15.07	12.38	15.67
	-08	6.73	8.19	7.54	9.11	12.38	15.26	13.10	16.10	13.62	16.70
	-09	7.26	8.76	8.17	9.74	13.01	16.25	14.23	17.13	14.80	17.73
	-10	7.79	9.33	8.80	10.37	13.64	17.23	15.36	18.16	15.96	18.76
	-11	8.32	9.90	9.43	11.00	15.81	18.21	16.49	19.19	17.09	19.79
	-12	8.85	10.47	10.06	11.63	16.78	19.18	17.62	20.22	18.24	20.82
	-13	9.36	11.03	10.69	12.26	17.73	20.13	18.75	21.25	19.36	21.86
	-14	9.91	11.60	11.32	12.89	18.69	21.09	19.88	22.28	20.51	22.89

*No 4-01 grip.

CR3523 - X - X = CR3523 - X - GX

10.11.02